

Work Order ID 157262

Friday, February 17, 2017 1:31:37 PM

157262

Page 1

Item ID: D2747 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Set Screw **100** FEB 24 2017
Start Date: 2/21/2017 Start Qty: 50.00 ***50*** Cust Item ID:
Required Date: 3/3/2017 Req'd Qty: 50.00 ***50*** DAS 13 9-89 Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: FEB 22 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2747	Rev B								DAS 13 9-89
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 35412 3/8"-24 UNF SS Set Screw 7/8" to 1" longPossible Supplie: McMaster CarrP/N:92311A639Material release note required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.17							
Packaging	Ensure material release note is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

100 FEB 24 2017**100x SP 1702-27****100** **DAS 38 9-89**
FEB 28 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Stop *NS2*

Customer:

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

0.00

0.08

Memo

QC21- Final Inspection - Work Order Release	0.00
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0.83

Memo

DAS
21
9-89

MAR 02 2017

DAS
21
9-89

MAR 02 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Description Work Order Deviation				Disposition					
								Completed By	
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Root Cause				FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐		
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____					
Misidentified ☐	Past Due ☐						

Picklist Print

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/

Work Order ID: 157262

157262

Parent Item: D2747

D2747

Parent Item Name: Set Screw

Start Date: 2/21/2017

Required Date: 3/3/2017

Start Qty: 50.00

Required Qty: 50.00

Comments: IPP: B05.08.22ReformatKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
92311A639 *92311A639* SS SET SCREW		Purchased	No			100	Each	0.0000	1	50 **			

100x sp 17-02-27

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

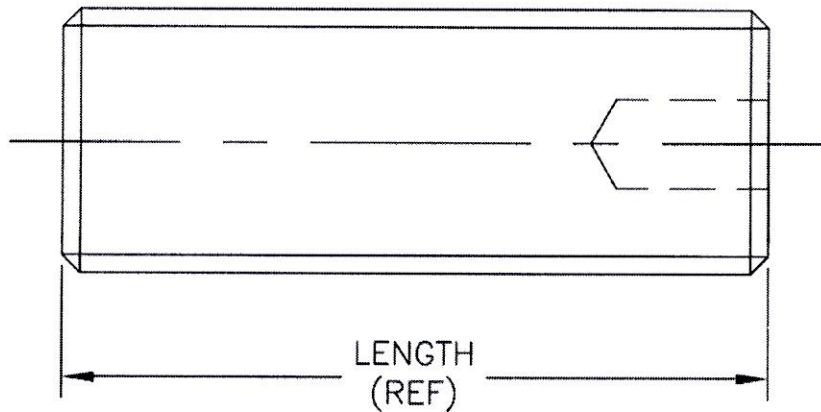
Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
								Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	☐ OTHER : _____					
Misidentified ☐	☐ Past Due						

DART

DESIGN DS	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2747	REV. B SHEET 1 OF 1
DATE 05.03.09		TITLE SET SCREW	SCALE NTS
A	98.08.26	NEW ISSUE	
B	05.03.09	REDRAWN, STAINLESS STEEL ONLY	

RELEASED
05-08-09 *[Signature]***D2747 SET SCREW**

- 1) TYPE: HEX SOCKET HEAD SET SCREW
- 2) MATERIAL: STAINLESS STEEL
- 3) THREAD: 3/8"-24 UNF
- 4) LENGTH = 7/8" TO 1"
- 5) FINISH: NONE
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157262
17-02-22
MCS

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO35412

Purchase Order Date 2/24/2017

PO Print Date 2/24/2017

Page Number 1 of 5

Order From :
MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

VU-MCM001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FEB 24 2017

E-MAILED

Contact Name		Buyer	Chantal Lavoie
Vendor Phone	330 995 5500	Customer POID	
		Customer Tax #	10127-2607
Ship To Contact		Terms	Net 10
Ship To Phone		Currency	USD
Ship Via:	Purolator ground ppd	FOB	FCA - (Free Carrier)
Ship Acct:			

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	92311A639	SS SET SCREW	2/28/2017 Yes 2/28/2017		100.00 Each	\$0.66	\$66.19
	AS PER DWG D2747 REV. B B157262						
						Line Total:	\$66.19
2	6605K56	HOOK AND LOOP TIE	2/28/2017 Yes 2/28/2017		15.00 Each	\$2.94	\$44.16
	AS PER DWG D3551 REV. A B157199					Line Total:	\$44.16
3	9776K33	Hook And Loop Strip 1"	2/28/2017 Yes 2/28/2017		75.00 f	\$1.17	\$87.87
	AS PER DWG D3800 REV. B B157450						

Note:

2/24/2017



200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO35412

Order Placed By
Chantal Lavoie

McMaster-Carr Number
7570662-02

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02/24/2017

Line	Product	Ordered	Shipped
1	92311A639 18-8 Stainless Steel Cup Point Set Screw 3/8"-24 Thread, 1" Long, Packs of 10	10 Packs	10
2	6605K56 Hook and Loop Cable Ties 24" Overall Length, Meets UL 94V2, Packs of 5	3 Packs	3
3	9776K33 1" Wide x 75' Long Hook, Adhesive Back, Beige	1 Each	1
4	6718K52 303 Stainless Steel Industrial-Shape Air Hose Coupling Plug, 1/4 Coupling Size, 1/4 NPTF Female End	12 Each	12
5	7263T82 Graduated Glass Flask 8.5 oz./ 250 ml Capacity, 3" Diameter, Deliver To: Gary	2 Each	2
6	6057K114 BX-Section Cogged V-Belt BX34 Trade Size, 37" Outer Circle, Deliver To: Luc	1 Each	1
7	6057K225 BX-Section Cogged V-Belt BX39 Trade Size, 42" Outer Circle, Deliver To: Luc	1 Each	1
8	2742A513 Countersink for Aluminum, Brass, and Bronze 3-Flute, 100 Degree Angle, 1/2" Body Diameter, 1/4" Shank Diameter	4 Each	2
9	4526A13 Hand-Held Grinding Wheel Cleaner with Spiral Cutters, for Smooth Surface, 2-3/8" Head Width, Deliver To: Dan P	1 Each	1
10	4530A1 Spur Cutter for Hand-Held Grinding Wheel Cleaner, with 1-1/2" Wide Head, Deliver To: Dan P	1 Each	1
12	8947A141 118 Degree Point High-Speed Steel Short-Length Drill Bit Bright Finish, 31/64", 3-11/16" Overall Length, Deliver To: Dan P	2 Each	2
13	3096A319 High-Speed Steel Extended-Reach Drill Bit Black Finish, Wire Gauge #9, 3.33" Drill Depth, Deliver To: Dan P	2 Each	2

Shipped separately from our Chicago warehouse on 02/24

8	2742A513 Countersink for Aluminum, Brass, and Bronze 3-Flute, 100 Degree Angle, 1/2" Body Diameter, 1/4" Shank Diameter	4 Each	2
11	2848A42 Keyless Drill Chuck 0-3/8" Capacity, 3/8"-24 Thread Mount	1 Each	1

DAS
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9-89